

order 10283

8 Nov



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D350-607-501
Job Sheet 184539



6083

Part No: D350-607-501

Job Qty: 2 ea

Part Name: Conversion Squirrel Cheek Compatible (Fits LH or RH)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/11/18

Job Tracking No:

Due Date: 11/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E SHEET 23 IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP REV:B 12.03.06 AS PER ECN12-535 DD VERF:EC IPP REV:C 14.06.09 AS PER ECN14-572 DD VERF:JLM IPP Rev.D 17.06.08 As per IIN RevE DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	11/8/18	11/8/18	0.00	0.00	Start Up Stores/Pkg-2		OCT 24 2018
140	Packaging	2 pcs	11/8/18	11/8/18	0.00	0.00	Packaging1-3	DAS 69	NOV 02 2018
150	QC	2 pcs	11/8/18	11/8/18	0.00	0.00	QC4	DAS 69	21
160	Packaging	2 pcs	11/8/18	11/8/18	0.00	0.00	Packaging3-1	9-89 69	9-89
165	DC	2 pcs	11/8/18	11/8/18	0.00	0.00	DC	9-89	NOV 02 2018
170	QC21-FG	2 Ea	11/8/18	11/8/18	0.00	0.00	QC21	DAS 21	NOV 02 2018

Part Op 160 - Identify and pack for shipping as per PPP D350-607-501
Descriptions: 165 - Photocopy bluefile & type labels per PPPD350-607-501 CHG006

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310C4	Nut	2 Ea (1 ea)	90-Start up Operation	5065268-1
AN4-13A	Bolt	12 Ea (6 ea)	90-Start up Operation	5089302
AN4-14A	Bolt	44 Ea (22 ea)	90-Start up Operation	5106950
AN4-42A	Bolt	8 Ea (4 ea)	90-Start up Operation	5106970
AN4C15	BOLT	2 Ea (1 ea)	90-Start up Operation	5113600
AN6-13A	Bolt	4 Ea (2 ea)	90-Start up Operation	5098644
D2690-6	Lanyard	2 Ea (1 ea)	90-Start up Operation	5114849
D3910-3	Crosstube Lug	4 Ea (2 ea)	90-Start up Operation	5118295
D3910-5	Crosstube Lug	2 Ea (1 ea)	90-Start up Operation	5067439
D3910-7	Crosstube Lug	2 Ea (1 ea)	90-Start up Operation	5116273
D3912-041	Eyebolt Receiver Assembly	2 Ea (1 ea)	90-Start up Operation	5122426
D3984-30	Rubber Extrusion, Crosstube (\$ Per Foot)	4 Ea (2 ea)	90-Start up Operation	5113902 511865 5X14
D4148-041	Fwd Crosstube Lug Assembly	2 Ea (1 ea)	90-Start up Operation	5120024
D4149-041	Aft Crosstube Lug Assembly	2 Ea (1 ea)	90-Start up Operation	5117468
D4150-041	Attachment Arm Assembly	2 Ea (1 ea)	90-Start up Operation	5115097
D4151-041	Basket Fwd Hardpoint Assembly, Lower	2 Ea (1 ea)	90-Start up Operation	5120921
D4151-043	Basket Fwd Hardpoint Assembly, Upper	2 Ea (1 ea)	90-Start up Operation	5121785
D4775-041	Strut Assembly	4 Ea (2 ea)	90-Start up Operation	5118799
D4776-3	Skidtube Clevis	4 Ea (2 ea)	90-Start up Operation	5122949
D4917-300	Placard, Max Load	2 Ea (1 ea)	90-Start up Operation	5090957
D4917-315	Placard, Max Load	2 Ea (1 ea)	90-Start up Operation	5067655

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube</td><td style="width:15%;">Cross tube</td><td style="width:15%;">Water Jet</td><td style="width:15%;">Engineering</td></tr> <tr> <td>Machining</td><td>Small Fab</td><td>Prod. Eng. Coord.</td><td>Quality</td></tr> <tr> <td>Thermoforming</td><td>Finishing</td><td>Rec/Store/Packaging</td><td>Other</td></tr> <tr> <td>Large Fab</td><td>Composite</td><td>Supplier</td><td></td></tr> </table>				Skid-tube	Cross tube	Water Jet	Engineering	Machining	Small Fab	Prod. Eng. Coord.	Quality	Thermoforming	Finishing	Rec/Store/Packaging	Other	Large Fab	Composite	Supplier	
Skid-tube	Cross tube	Water Jet	Engineering																				
Machining	Small Fab	Prod. Eng. Coord.	Quality																				
Thermoforming	Finishing	Rec/Store/Packaging	Other																				
Large Fab	Composite	Supplier																					
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation				Disposition																			
				Completed By _____																			
				/ Supervisor Verification _____																			
				Coordinator Approval _____																			

Root Cause		FAULT CATEGORY					
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

Container No: S123994
 Part: D350 - 607 - 501
 Job No: 184539
 Serial No/Batch: S123994
 Revision: E
 Inspector:
 Exp Date:
 Instructions: TC STC SH94 - 14 Issue 7 of 7
 DART Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

D4917-320	Placard, Max Load	2 Ea (1 ea)	90-Start up Operation	5044857
D4917-332	Placard, Max Load	2 Ea (1 ea)	90-Start up Operation	5090639
MS17984-C413	Quick Release Pin	2 pcs (1 ea)	90-Start up Operation	5118385
MS21042L4	Nut	64 Ea (32 ea)	90-Start up Operation	5094597
MS21042L6	Nut	4 Ea (2 ea)	90-Start up Operation	5083582
MS24665-151	Cotter Pin	2 Ea (1 ea)	90-Start up Operation	5003951
NAS1149C0463R	Washer	6 Ea (3 ea)	90-Start up Operation	5053953
NAS1149F0432P	Washer	112 Ea (56 ea)	90-Start up Operation	5083558
NAS1149F0663P	Washer	8 Ea (4 ea)	90-Start up Operation	5057477
NAS1515H4L	Washer	4 Ea (2 ea)	90-Start up Operation	5044185
D3501-1	Bushing	16 Ea (8 ea)	90-Start up Operation	5094369
D4085-3	Placard	2 Ea (1 ea)	90-Start up Operation	5083558 5125413
D4713-1	Spacer	2 Ea (1 ea)	90-Start up Operation	5057477 50915336
MS3367-5-0	Tie Wrap	2 Ea (1 ea)	90-Start up Operation	5050161

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN310C4	2	125	0
	AN4-13A	12	1,396	0
	AN4-14A	44	1,419	0
	AN4-42A	8	139	0
	AN4C15	2	29	0
	AN6-13A	4	87	0
	D2690-6	2	31	0
	D3501-1	16	464	0
	D3910-3	4	5	0
	D3910-5	2	21	0
	D3910-7	2	34	0
	D3912-041	2	2	0
	D3984	4	106	0
	D4085-3	2	34	0
	D4148-041	2	6	0
	D4149-041	2	8	0
	D4150-041	2	20	0
	D4151-041	2	2	0
	D4151-043	2	0	0
	D4713-1	2	29	0
	D4775-041	4	12	0
	D4776-3	4	20	0
	D4917-300	2	18	0
	D4917-315	2	10	0
	D4917-320	2	7	0
	D4917-332	2	9	0
	MS17984-C413	2	51	0
	MS21042L4	64	4,617	0
	MS21042L6	4	378	0
	MS24665-151	2	225	0
	MS3367-5-0	2	752	0
	NAS1149C0463R	6	294	0
	NAS1149F0432P	112	1,180	0
	NAS1149F0663P	8	665	0
	NAS1515H4L	4	207	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				8	8	D3501-1	BUSHING
				2	2	D3910-3	X-TUBE LUG
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1					1	D4917-300	PLACARD, MAX LOAD
1						D4086-200	PLACARD, MAX LOAD
	1				1	D4917-315	PLACARD, MAX LOAD
	1					D4086-215	PLACARD, MAX LOAD
		1			1	D4917-320	PLACARD, MAX LOAD
		1				D4086-220	PLACARD, MAX LOAD
			1		1	D4917-332	PLACARD, MAX LOAD
1	1	1	1	1	1	D4085-3	PLACARD, INSTRUCTIONS
			1			D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
				1	1	D4713-1	SPACER
				2	2	D4775-041	STRUT ASSEMBLY
				2	2	D4776-3	SKIDTUBE CLEVIS
6	6	6	6		6	AN4-13A	BOLT
				20	22	AN4-14A	BOLT
				4	4	AN4-42A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
				2	2	AN6-13A	BOLT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	24	32	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21042L6	NUT
1	1	1	1		1	MS24665-151	COTTER PIN
				1	1	MS3367-5-0	TIE WRAP
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	40	56	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER
				4	4	NAS1149F0663P	WASHER

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